

Date: Thursday, 2/9/2006 1:51:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUAL HIGH BACK SEAT
 Job Number : 25786
 Estimate Number : 12271
 P.O. Number : N/A Part Number : D350689041
 This Issue : 2/9/2006 S.O. No. : N/A Drawing Number : ~~N/A~~ 1113-D350-689 Rev.A pg 9
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : N/A
 Previous Run : 25785 Material : N/A
 Written By : See COMMENT Below Due Date : 2/28/2006 Qty: 1 Um: Each
 Checked & Approved By : 06.02.09
 Comment : Est Rev:H Removed Sub-Parts 06-02-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30241 Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3024-1 Spacer B24629

2.0 D30281 Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3028-1 Stud B24630

3.0 D30291 Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3029-1 Spring B24962

4.0 D30301 Lock



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3030-1 Lock B24631

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 25786

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30311

Loop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3031-1 Loop B27949

6.0

AN312A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-12A Bolt M18310

7.0

AN960JD10L

Washer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 AN960JD10L Washer M101291

8.0

MS21042L3

Nut



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 MS21042L3 Nut (or -3) M100094

9.0

MS24693S272

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS24693-S272Screw M10248

10.0

MS27039117

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-17 Screw M11540

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 25786

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS27039119

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS27039-1-19 Screw (4) M11573 (8) M100089

12.0

D30231

Back Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3023-1 Back Panel B25798

13.0

D30221

Seat Pan



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3022-1 Seat Pan B25962

14.0

D3021041

Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3021-041 Tube Assembly B25794

15.0

D3016041

Seat Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3016-041 Frame Assembly B25960

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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16.0	D3017041	Back Frame Assembly
------	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3017-041 Back Assembly B25792

See Attached

(P10)

17.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg

SB 06/03/14 (1)

18.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06-08-14 (1)

19.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AB 06/02/15 (1)

20.0	DC	DOCUMENT CONTROL
------	----	------------------



Comment: DOCUMENT CONTROL

Inspection Level 21

DO 06/08/15 (1)

Job Completion



C Loe 08/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-06-14	160	Add steps AS per Attached sheet.					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/08/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/14	17	Stud D 3028-1 were too big of .005"		Tap bolt to clean threads for proper R.T.	SB 06/08/14			

NOTE: Date & initial all entries

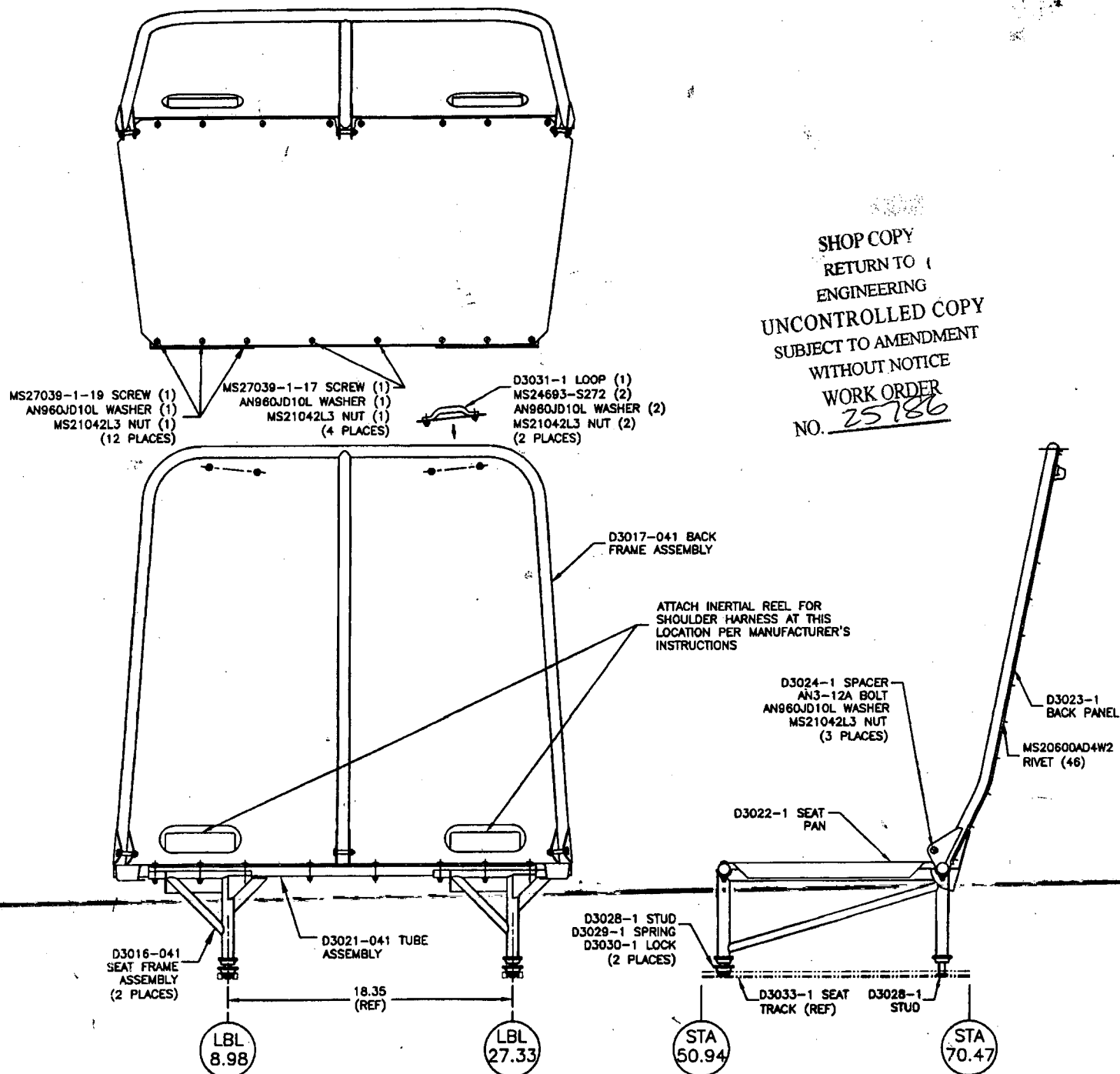


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A

Date: 01.05.30

DART AEROSPACE LTD	Work Order:	
Description: Dual High Back Seat Assembly	Part Number:	D350-689-041
Dwg: IIN-D350-689 Rev. A page 9; D3016 Rev. A; D3017 Rev. A D3021 Rev. A; D3022 Rev. A; D3023 Rev. A	Qty:	Page 3 of 3

Step	Location	Procedure	By	Date	Qty																																																
28	GA	Rivet back panel (D3023-1) to back frame (D3017-1) as per Dwg IIN-D350-689 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>40</td><td>MS20600AD4W2</td><td>Rivet</td><td>M4747</td></tr><tr><td>6</td><td>MS20600AD4W3</td><td>Rivet</td><td>M14393</td></tr></tbody></table>	Qty	Part Number	Description	Batch	40	MS20600AD4W2	Rivet	M4747	6	MS20600AD4W3	Rivet	M14393	SB	06/08/07	1																																				
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40	MS20600AD4W2	Rivet	M4747																																																		
6	MS20600AD4W3	Rivet	M14393																																																		
29	QC5	Inspect work to Step 28		06-08-10	1																																																
30	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3017-1 & D3023-1		06-08-10	1																																																
31	QC3	Inspect Powder Coat		06-08-14	1																																																
32	GA	Assemble as per Dwg IIN-D350-689 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>3</td><td>D3024-1</td><td>Spacer</td><td></td></tr><tr><td>4</td><td>D3028-1</td><td>Stud</td><td></td></tr><tr><td>2</td><td>D3029-1</td><td>Spring</td><td></td></tr><tr><td>2</td><td>D3030-1</td><td>Lock</td><td></td></tr><tr><td>2</td><td>D3031-1</td><td>Loop</td><td></td></tr><tr><td>3</td><td>AN3-12A</td><td>Bolt</td><td></td></tr><tr><td>23</td><td>AN960JD10L</td><td>Washer</td><td></td></tr><tr><td>23</td><td>MS21042L3</td><td>Nut (or -3)</td><td></td></tr><tr><td>4</td><td>MS24693-S272</td><td>Screw</td><td></td></tr><tr><td>4</td><td>MS27039-1-17</td><td>Screw</td><td></td></tr><tr><td>12</td><td>MS27039-1-19</td><td>Screw</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	3	D3024-1	Spacer		4	D3028-1	Stud		2	D3029-1	Spring		2	D3030-1	Lock		2	D3031-1	Loop		3	AN3-12A	Bolt		23	AN960JD10L	Washer		23	MS21042L3	Nut (or -3)		4	MS24693-S272	Screw		4	MS27039-1-17	Screw		12	MS27039-1-19	Screw				
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4	MS27039-1-17	Screw																																																			
12	MS27039-1-19	Screw																																																			
33	QC5	Inspect work to Step 32																																																			
34	KP	Go back to D350-689-011 ready for packing																																																			

Rev	Date	Change	Revised By	Approved
A	01.05.29	New issue	EC	
B	01.10.24	Changed bolt	EC	
C	01.11.09	Revised Step 6, Added Inspection Level 21 and Drawings	SM	
D	01.12.21	Added Step 4	SM	
E	02.01.22	Combined D3016-041, D3021-041, D3017-041 and revised the process.	NG	
F	03.05.07	Reformat	KJ/RF	
G	05.06.20	Added Powder Coat	KJ/JLM	